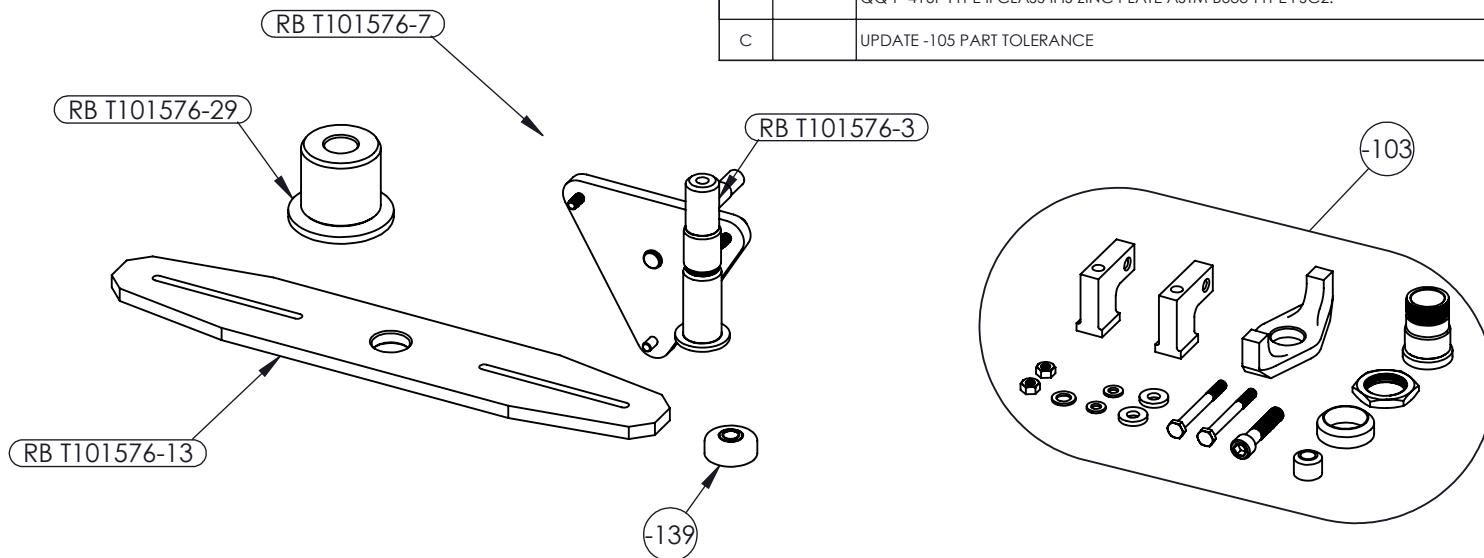


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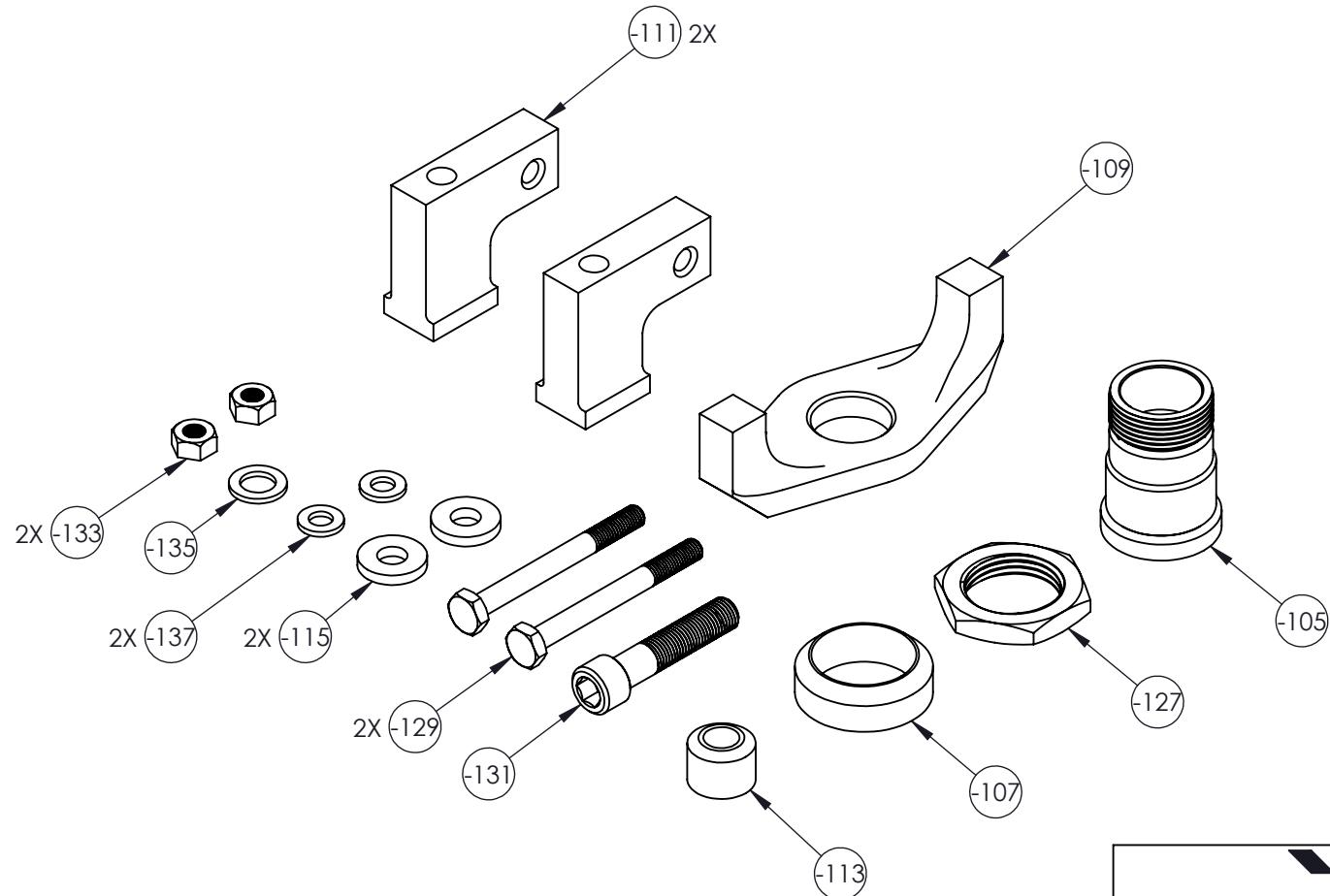
REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1		UPDATED SHEET FORMATS. BROKE PARTS OUT INTO INDIVIDUAL SHEETS. -105 ADDED MISSING DIM 59° TO INNER CHAMFER, ADDED DETAIL VIEW C, CORRECTED THREAD RELIEF ADDED 45° DIM. -111 ADDED MISSING DIMS .23 AND 2X R.06. -113 ADDED MISSING DIM .479.	12/5/2013	CFS	GE	
1A		CH'D TO BELL TOLERANCES.	4/9/2014	DPD	GE	
2	17-0165	UPDATED TO NEW STANDARD. CH'D USED ON MODEL WAS BELL 206 IS BELL 407, 427. -105 CH'D DIM WS 1-1/8-12 UNF IS 1-1/8-12 UNF - 2A. -111 CH'D DIM WAS .23 IS 2X .23. DELETED DIM .98. -127 CH'D DIM WAS 1.50 IS 3X 1.50. ADDED DIMS 2X .05, 2X 25°. CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416F TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2.	7/11/2017	DPD	JAG	
C		UPDATE -105 PART TOLERANCE	11/4/2020	SAD		



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ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	BASE		RB T101576-13	1
				1	PLUG (USE ON 206)		RB T101576-29	1
				1	MANDREL ASSY.		RB T101576-3	1
				1	STAND ASSY		RB T101576-7	1
X	-103			1	BALANCE SET ATTACHMENTS			2
1	-105				ADAPTER	440C COML. GR.		3
1	-107				LARGE SPACER	440C COML. GR.		4
1	-109				STOP	6061		5
2	-111				HALF STOP	6061		6
1	-113				SMALL SPACER	440C COML. GR.		7
2	-115				SPACER WASHER	440C COML. GR.		8
1	-127				THIN HEX NUT	STEEL		9
2	B/O	-129			HEX HEAD CAP SCREW	STEEL	(NAS6604-35 OR AN4-25A)	2
1	B/O	-131			SOCKET HEAD CAP SCREW	STEEL, BLACK	3/8-24 UNF X 1-3/4 (MCMASTER-CARR #91251A430)	2
2	B/O	-133			HEX NUT	STEEL	(NAS509-4 OR AN315-4R)	2
1	B/O	-135			FLAT WASHER	STEEL	(AN960-616)	2
2	B/O	-137			FLAT WASHER	STEEL	(AN960-416)	2
	B/O	-139	1		BULL'S EYE LEVEL		(MCMASTER-CARR #2147A11)	1
ASSY -103								

TITLE		RBT400284	
DWG NO.	REV	C	
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .010 FRACTIONS ± 1/8	
FINISH		.XX ± .03 ANGLES ± 1°	
SPEC		.X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES		.015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
DRAWN BY: SAD		USED ON MODEL	
CHECKED: KPT			
OPPS APPR: DD			
QA APPR: N/A		USED ON MODEL	
APPROVED: <i>M. Lee</i>		BELL 407, 427	
SCALE	1:5	DATE	11/4/2020
			SHEET 1 OF 9



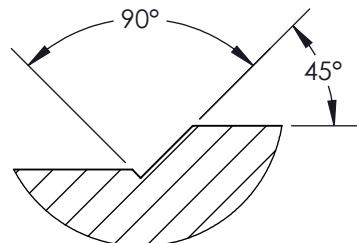
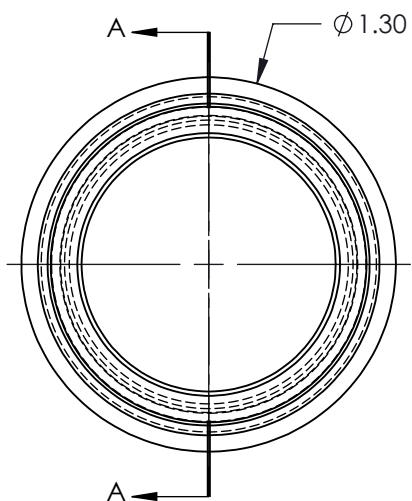
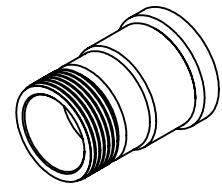
BALANCE SET ATTACHMENTS

-103

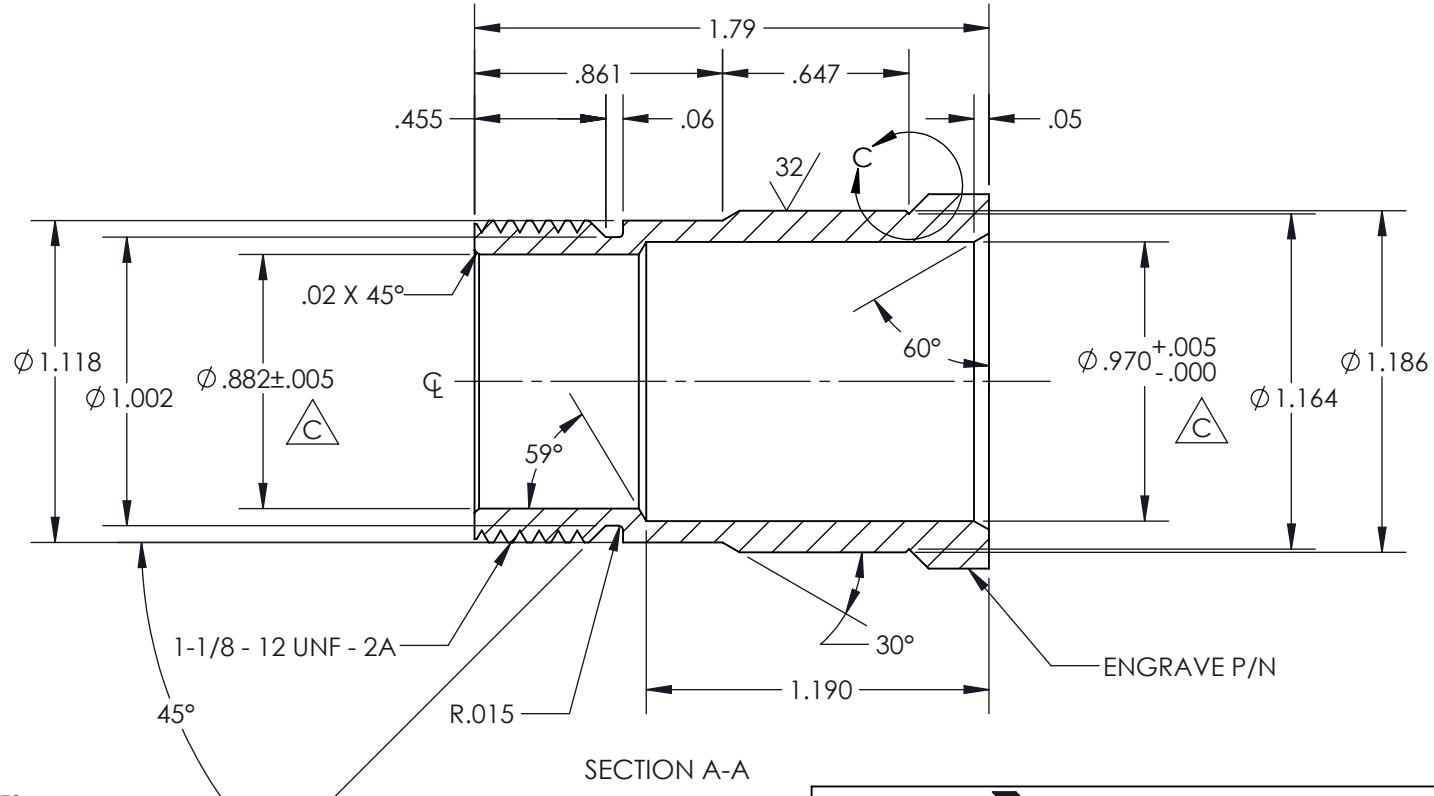
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DART AEROSPACE	
TITLE	
TAIL ROTOR BALANCE SET	
DWG NO.	
RBT400284-103	
REV C	
MAT'L	
HEAT	
TREAT	
FINISH	
SPEC	
DRAWN BY: SAD	
CHECKED: KPT	
OPPS APPR: DD	
QA APPR: N/A	
APPROVED: BELL 407, 427	
SCALE	1:2
DATE	11/4/2020
SHEET 2 OF 9	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ± 1°
.X ± .1 SURFACES = 125 ✓
1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009
USED ON MODEL
BELL 407, 427



DETAIL C
SCALE 4 : 1



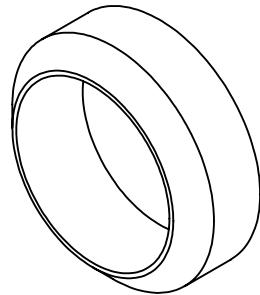
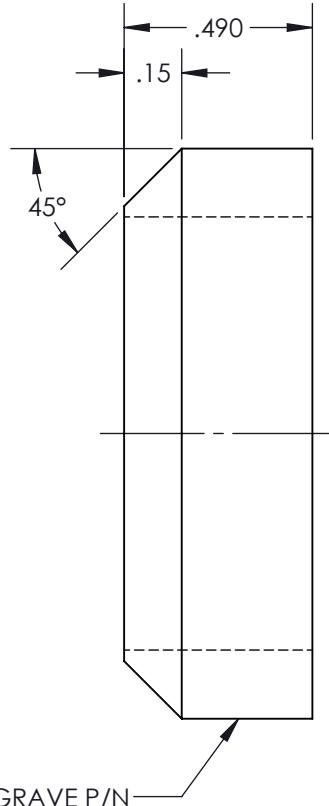
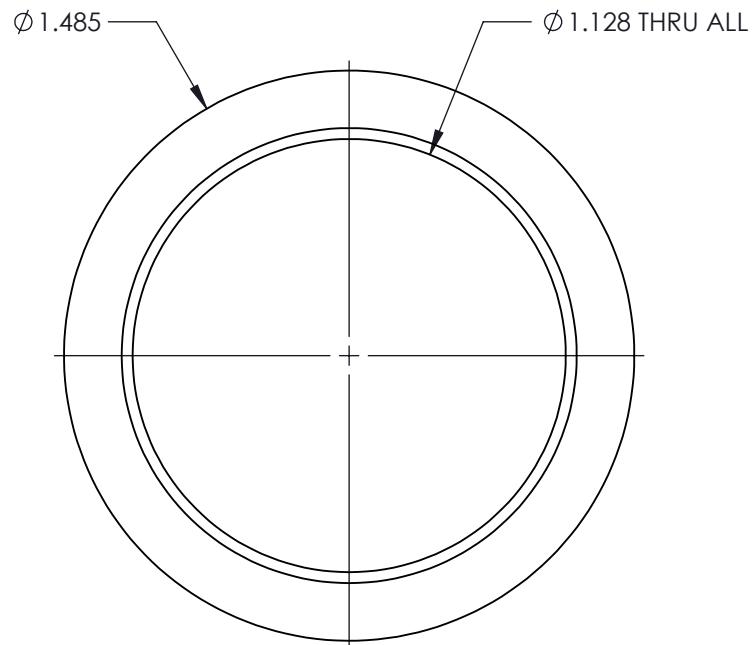
SECTION A-A

-105

ADAPTER

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TITLE	TAIL ROTOR BALANCE SET
DWG NO.	RBT400284-105
REV C	
MAT'L	440C COML. GR.
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
DRAWN BY:	SAD
CHECKED:	KPT
OPPS APPR:	DD
QA APPR:	N/A
APPROVED:	BELL 407, 427
USED ON MODEL	
SCALE	3:2
DATE	11/4/2020
SHEET	3 OF 9



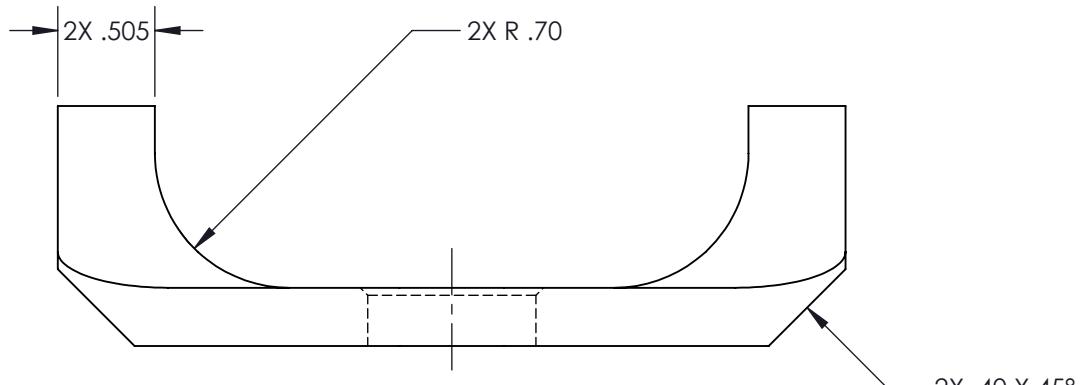
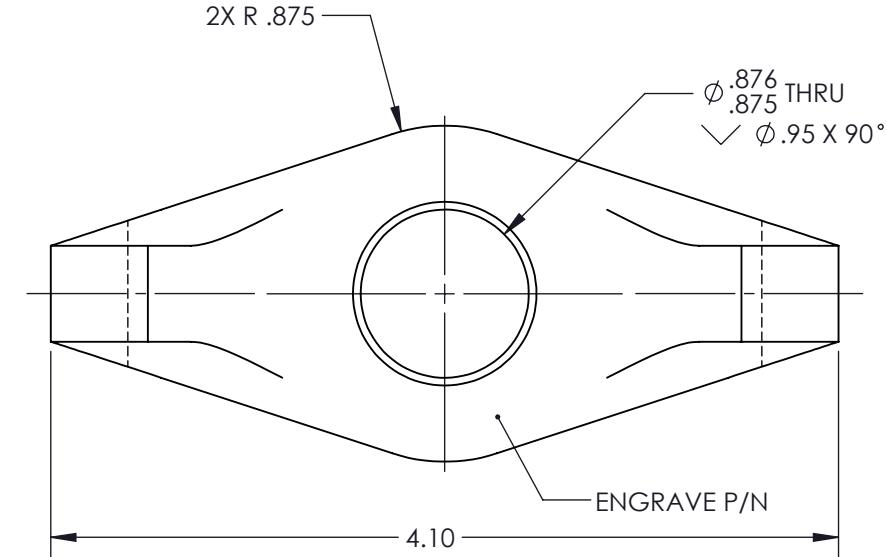
LARGE SPACER

-107

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2020 NOV 17

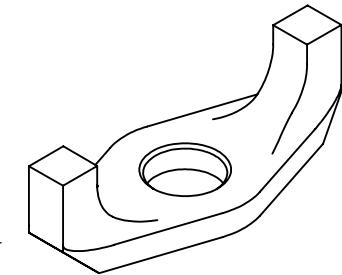
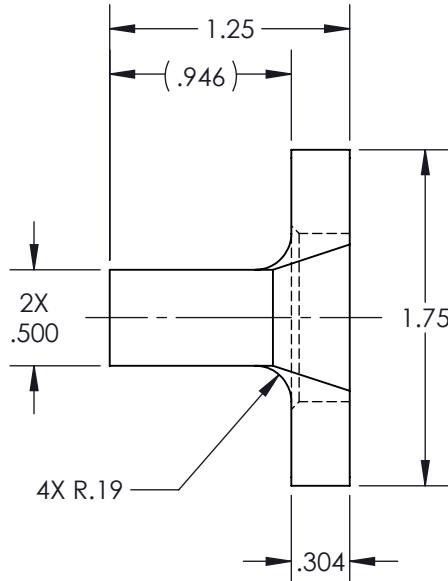
DART AEROSPACE	
TITLE	
TAIL ROTOR BALANCE SET	
DWG NO.	
RBT400284-107	
REV C	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX \pm .010 FRACTIONS \pm 1/8	
.XX \pm .03 ANGLES \pm 1°	
.X \pm .1 SURFACES = 125	
1. BREAK ALL SHARP EDGES	
.015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY	
AFTER PLATING	
3. INTERPRET DIM AND TOL PER	
ASME Y14.5M-2009	
USED ON MODEL	
BELL 407, 427	
SCALE	2:1
DATE	11/4/2020
SHEET 4 OF 9	

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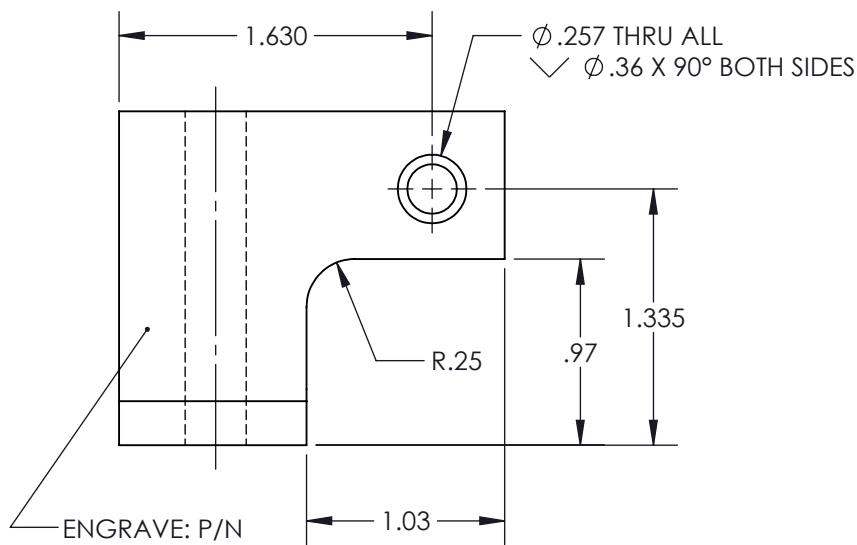
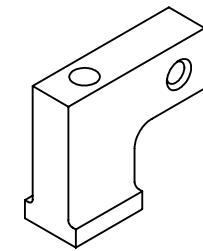
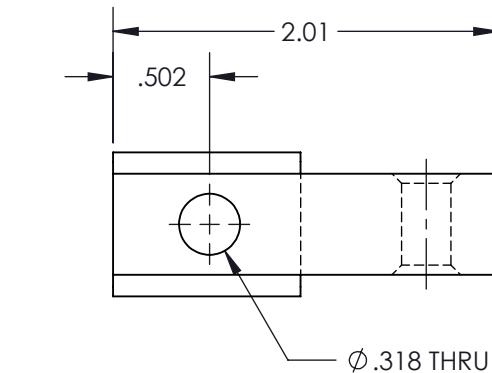
STOP



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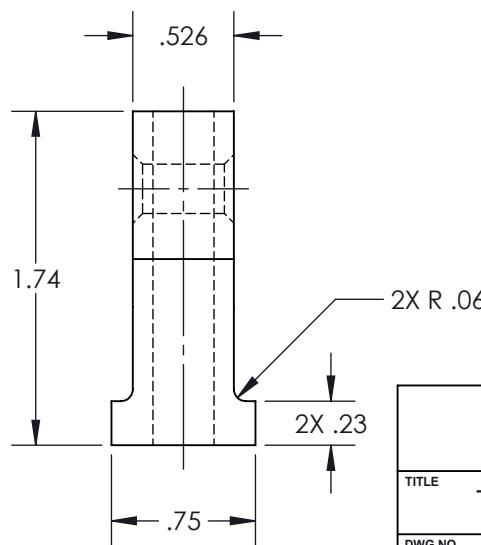
	
TITLE	
TAIL ROTOR BALANCE SET	
DWG NO.	
RBT400284-109	
REV C	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: SAD CHECKED: KPT OPPS APPR: DD QA APPR: N/A APPROVED: BELL 407, 427	
USED ON MODEL ASME Y14.5M-2009	
SCALE	1:1
DATE	11/4/2020
SHEET 5 OF 9	

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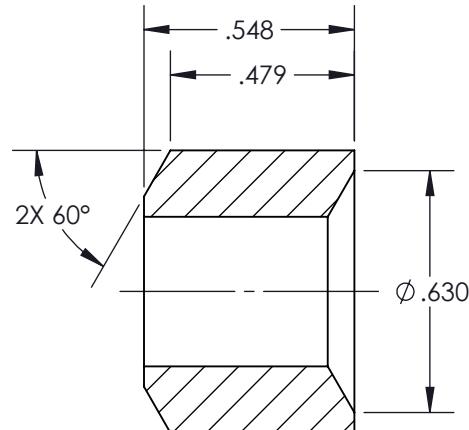
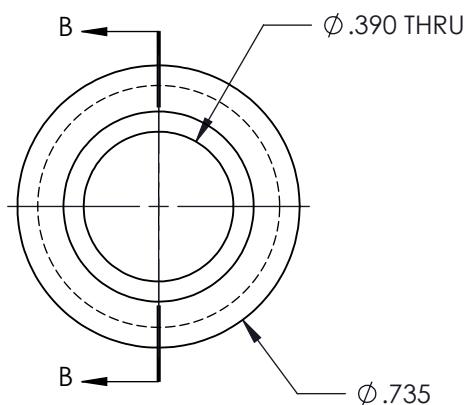
-111

HALF STOP



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2020 NOV 17

		TITLE	TAIL ROTOR BALANCE SET	
			DWG NO.	REV C
MAT'L 6061		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
HEAT		.XXX	$\pm .010$	FRACTIONS $\pm 1/8$
TREAT		.XX	$\pm .03$	ANGLES $\pm 1^\circ$
FINISH		CLEAR ANODIZE SURFACES = 125		
SPEC MIL-A-8625F, TYPE II, CLASS I		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		
DRAWN BY: SAD		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
CHECKED: KPT		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		
OPPS APPR: DD		USED ON MODEL		
QA APPR: N/A		BELL 407, 427		
APPROVED:		SCALE 1:1	DATE 11/4/2020	SHEET 6 OF 9



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2020 NOV 17

SECTION B-B

NOTE:
ATTACH TAG WITH PART NO.



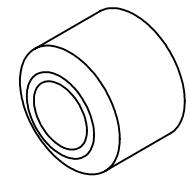
TITLE
TAIL ROTOR BALANCE SET

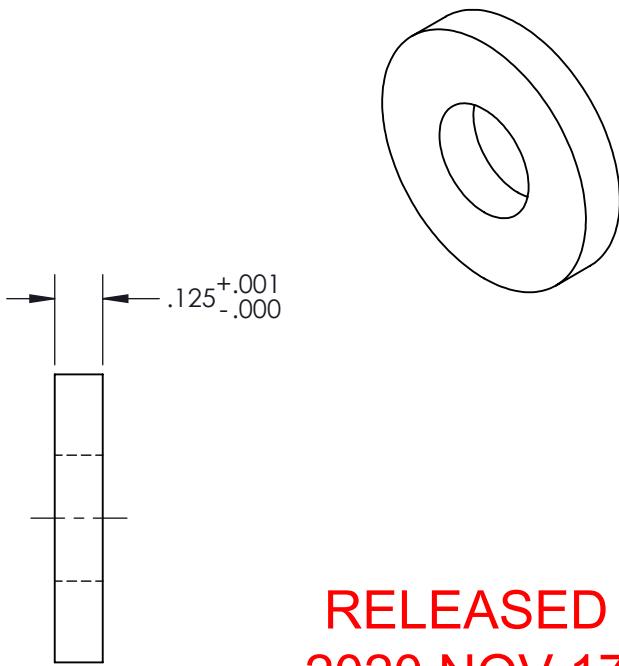
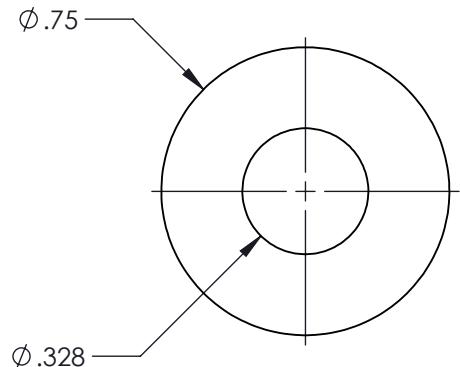
DWG NO. RBT400284-113 REV C

MAT'L	440C COML. GR.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX \pm .010	FRACTIONS \pm 1/8
TREAT	.XX \pm .03	ANGLES \pm 1°
FINISH	.X \pm .1	SURFACES = 125
SPEC		✓
DRAWN BY:	SAD	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED:	KPT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	DD	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	N/A	USED ON MODEL
APPROVED:		BELL 407, 427
SCALE	2:1	DATE 11/4/2020
		SHEET 7 OF 9

-113

SMALL SPACER





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2020 NOV 17

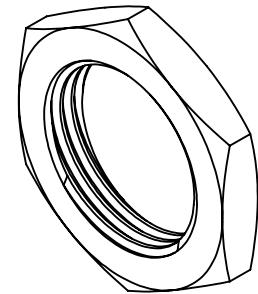
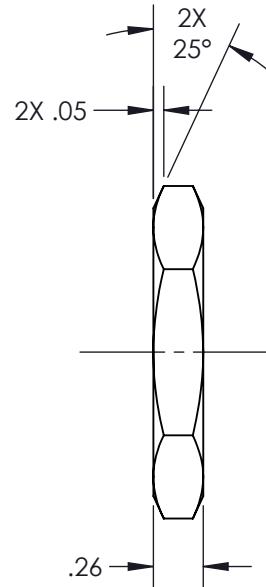
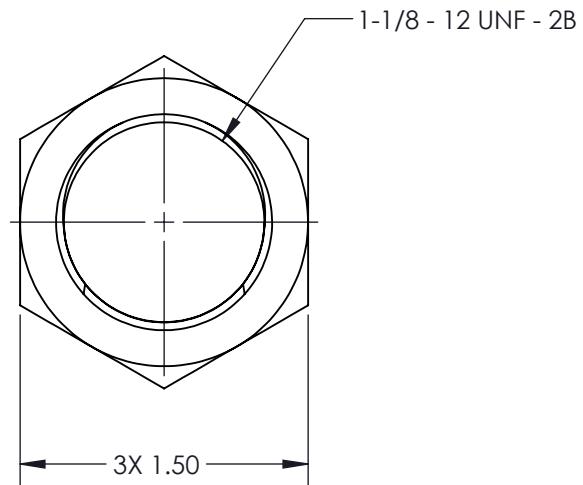
NOTE:
ATTACH TAG WITH PART NO.



TITLE		TAIL ROTOR BALANCE SET	REV
DWG NO.		RBT400284-115	C
MAT'L	440C COML. GR.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT		.XXX \pm .010	FRACTIONS \pm 1/8
TREAT		.XX \pm .03	ANGLES \pm 1°
FINISH		.X \pm .1	SURFACES = 125
SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:	SAD	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED:	KPT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR:	DD	USED ON MODEL	
QA APPR:	N/A	BELL 407, 427	
APPROVED:			
SCALE	2:1	DATE	11/4/2020
			SHEET 8 OF 9

-115

SPACER WASHER



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2020 NOV 17

-127

THIN HEX NUT

DART AEROSPACE	
TITLE	
TAIL ROTOR BALANCE SET	
DWG NO.	
RBT400284-127	
REV C	
MATERIAL STEEL	
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
ASTM B633 TYPE I SC 2	
DRAWN BY:	SAD
CHECKED:	KPT
OPPS APPR:	DD
QA APPR:	N/A
APPROVED:	BELL 407, 427
USED ON MODEL	
SCALE	1:1
DATE	11/4/2020
SHEET 9 OF 9	

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009